

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012186**Date Inspected:** 17-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of OBG component - Traveler Rail, weld joint 20TR1-019 – 001, 005 & 007. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-7-1G.

Flux Cored Arc Welding (FCAW) of OBG component - Traveler Rail, weld joint 20TR1-020 – 003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-7-1G.

Bay 3:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of OBG component - Traveler Rail, weld joint 20TR1-013 – 011, 013 & 015. Welder is identified as 214945. ZPMC Quality Control (QC) is identified as Yin Dong Hai. The welding variables

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recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-7-1G.

For Cross Beams (CB):

Bay 6: CB9.

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay6: CB9.

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB8, CB13, CB10, CB11, CB15, CB16, CB12 & CB14:

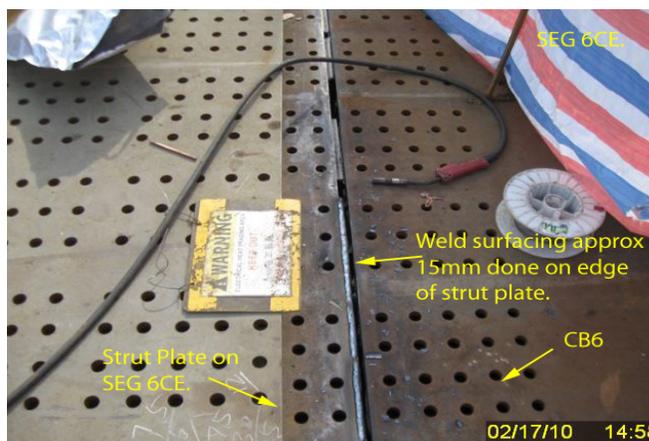
This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Trial Assembly: CB6.

This QA Inspector observed ZPMC personnel performing weld built up / surfacing on the square edge of SEG 6CE. This built-up was done having Welding Repair Report (WRR) – B-WR10561. Built-up was required to be done in order to maintain the centre distance between the Holes on the Strut Plate and Top Panel of Cross Beam CB6. Welding process was identified as Flux Cored Arc Welding (FCAW) & welders were identified as 066439 & 067609. ZPMC Quality Control (QC) was identified as Li Yang.

For further information, refer attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
